

DART AEROSPACE LTD	Work Order:	23122
Description: Back frame ass'y	Part Number:	D3017-041
Drawing: D3017 Rev. A	Qty:	1

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	VL	05/04/27	1
2	METAL	Cut: - AISI 4130N tube, Ø3/4" x 0.049" wall batch: M9530	MA	05/04/27	1
3	METAL	Cut all tubes as per Dwg D3017	MA	05/04/27	1
4	METAL	Deburr	MA	05/04/27	1
5	METAL	Cut: - AISI 4130N sheet, 18 gauge (0.050 thick) batch: M16443	MA	05/04/28	1
6N	METAL	Cut end caps as per Dwg D3017	MA	05/04/28	1
7	STORES	Pick: Qty Part Number Description Batch 3 D3017-7 Lug B22411	MA	05/04/28	1
8	QC	Inspect Level 5	2	05-04-28	1
9	WELDING	Weld as per Dwg D3017 using Welding Jig DT8598	MA	05/04/28	1
10	QC	Inspect Level 9	2	05-04-28	1
12	FINISHING	Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005	FF	05/4/28	1
13A	QC	Inspect Level 3	ML	05 04 28	1
14	STORES	Identify and stock	CL	05/04/29	1
15	EXPEDITING	Close W/O Cost / part 387.35 59c 05/05/02 (1)	CL	05.04.29	1

Rev	Date	Change	Revised By	Approved
A	01.09.19	New issue	EC	RE

6b	Metal	cut Alum back 2024 T35.032 B M15120	MA	05/04/28	1
6c	Metal	Drill holes - Deburr	MA	05/04/28	1
6d	Metal	Form	MA	05/04/28	1
13b	Metal	Rivet panel to Frame	MA	05/04/28	1
13c	QC	Inspection	MA	05/04/28	1
13d	Finishing	Powder Coat Grey	FF	05/4/28	1
13E	QC	Inspection	ML	05 04 28	1

PTO

13 F Metal Pick and assemble

→ qty

3 Δ3024-1 ~~Δ~~ 22070

2 Δ3031-1 ~~Δ~~ 17173

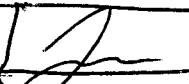
3 AV3-12A M15387

7 AN960JΔ10L M16612

7 MS21042L3 M15924

4 MS24693-5272 M10248

05/04/28

13g	QCH	inspection		1
14	PL	package per SPP	05/04/29	
			05/04/29	1

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

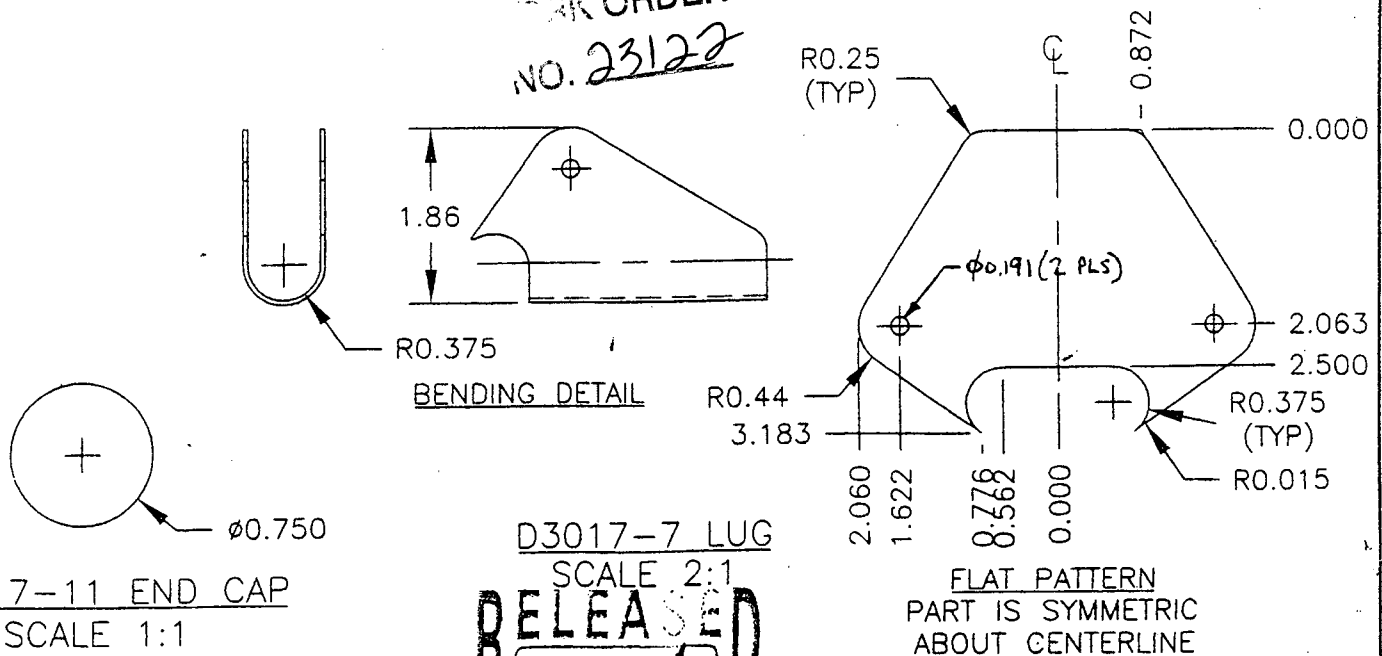
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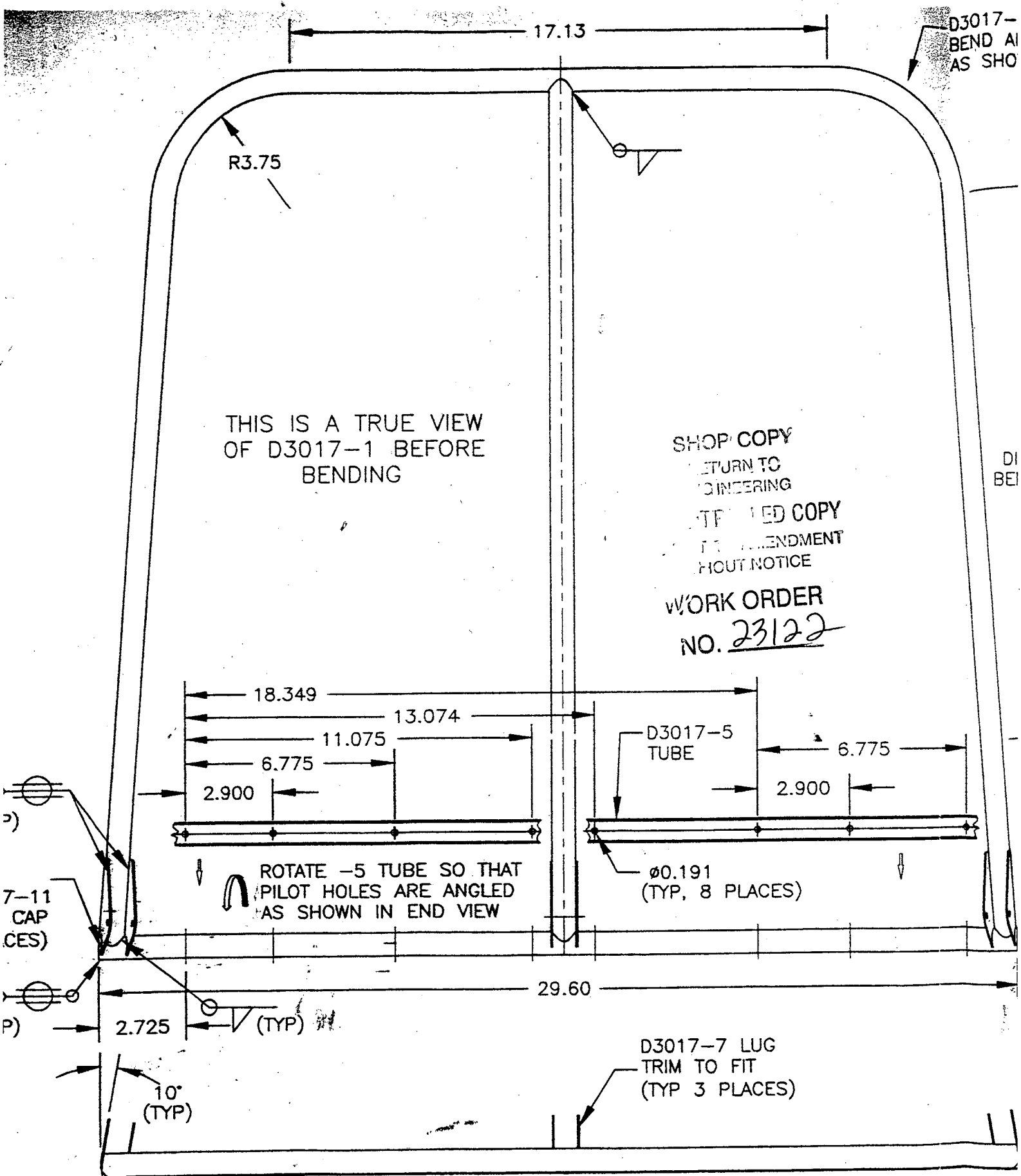
ENDMENT

NOTICE

ORDER
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NO. 23122

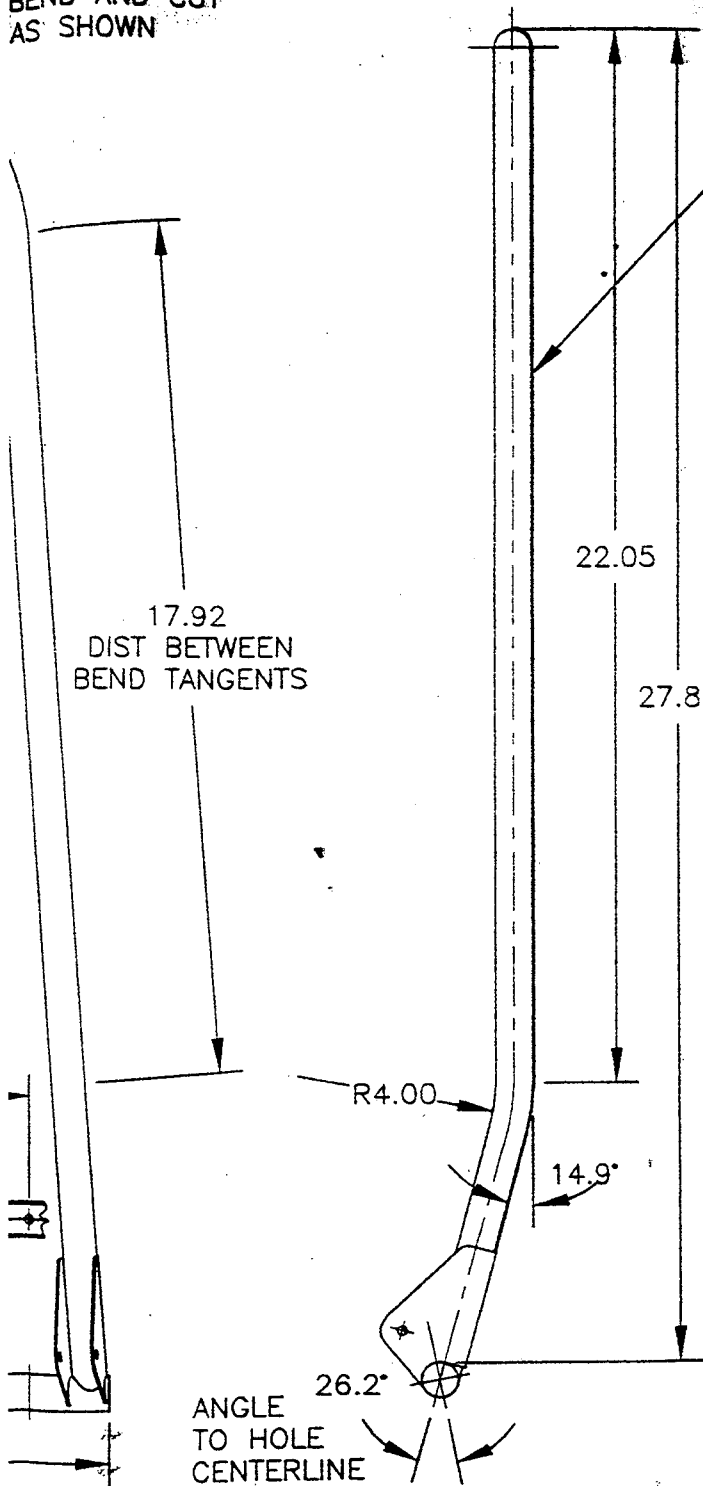
7-11
CAP
CES)
P)

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BEI

RELEASED
01-06-07

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

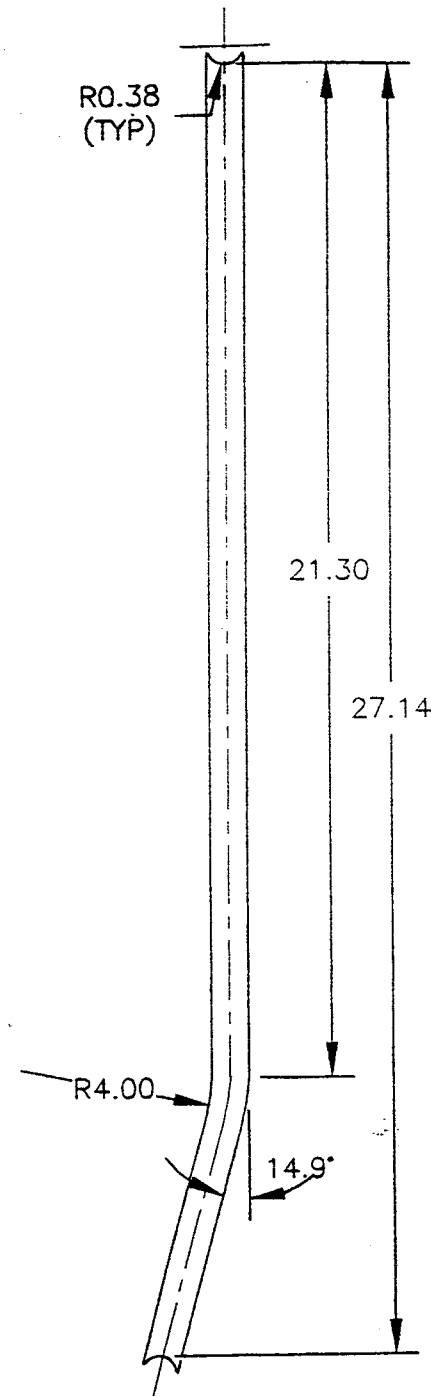
D3017-1 TUBE,
BEND AND CUT
AS SHOWN



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(TYP)



D3017-3 TUBE

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	CHECKED	APPROVED	
	DATE	TITLE	
	01.05.18	BACK FRAME ASSEMBLY	
		DRAWING NO.	REV.
		D3017	SHEET 2 OF
			SCA